| Work Order ID 7395 | Work | Order | ID | 73953 |
|--------------------|------|-------|----|-------|
|--------------------|------|-------|----|-------|



Page 1 Tuesday, September 20, 2011 10:17:02 AM Item ID: D3529-1 Accept Setup Start **Revision ID:** Item Name: Bearpaw Start Date: 9/20/2011 Start Qty: 4.00 **Cust Item ID:** Required Date: 10/4/2011 Req'd Qty: 4.00 **Customer:** Reference: Run Start Date: 11-09-20 Process Plan: Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr** Revision Nbr D3529 Rev A 110 0.00 FLOW WATER JET Wateriet 0.00 Memo FLQW CNC Wateriet CUT BLANK AS PER FILE D3529-1BLANK 120 0.00 HAAS CNC VERTICAL MACHINING #1 11/10/19 HAAS 1 0.00 Memo HAAS CNC vertical machine #1 1-Inspect material for defects or damage prior to machining 22-Machine as per Folio FA645 and Dwg D3529 □ 3-Deburr 130 QC2- Inspect parts off machine FAI/FAIB 0.00 EK. 11/10/19 QC

Memo

Quality Control

| W/O: | | | W | ORK ORDER CHANG | GES | | | | | |
|---------|------|--------------------------|------------|---------------------------------|---------|----------|--------------|-------------|-------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE By Date | | | | | | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | • | PAR #: | Fault Cate | gory: | NCF | R: Yes N | lo DQ | A: | Date: | |
| | Res | solution: | Dispositio | n: | QA: | N/C Clo | sed: | | Date: _ | |
| NCR: | | | WORK ORD | ER NON-CONFORM | ANCE | (NCR) | • | | | |
| DATE | STEP | Description of NC | Initial | | ction B | Sign & | | cation | Approval | Approval |
| | | Section A | Chief Eng | Action Description Chief Eng | | Date | Secti | on C | Chief Eng | QC Inspector |
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Work Order ID 73953



Page 2

Tuesday, September 20, 2011 10:17:02 AM

Item ID:

D3529-1

Accept

Setup Start

Stop



Revision ID:

Item Name:

Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 4.00

Req'd Qty: 4.00

Customer:

Cust Item ID:

Reference:

Approvals:

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start

Reject

Qty

Stop

Sequence ID/

Operation

QC8- Inspect parts - second check

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept **Qty**

Reject Number

Insp. Stamp

140

Work Center ID

Quality Control

Description

Memo

0.00

0.00

Run

150

Packaging

Packaging

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release

0.00

PP113952

0.00

160

0.00

Memo

0.00

Quality Control

| | • | | | | | | | | |
|---------|------|-------------------|----------------------|------------------------------|-----------|-----------------|------------|-------------------------------------|--------------------------|
| W/O: | | | WO | RK ORDER CHANC | SES | | | | |
| DATE | STEP | PRO | OCEDURE CHAN | IGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No |): | PAR #: | Fault Categ | ory: | NCR: Yes | No DQ | A : | Date: _ | |
| | Re | solution: | Disposition | • | QA: N/C (| Closed: | | Date: _ | |
| NCR: | | | WORK ORDE | R NON-CONFORM | ANCE (NC | R) | | | |
| DATE | STEP | Description of NC | | | tion B | Sign & Verifica | | tion Approval | Approval |
| DAIL | JILI | Section A | Initial Chief Eng | Action Description Chief Eng | | | ion C | Chief Eng | QC Inspector |
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Picklist Print

Tuesday, September 20, 2011 10:17:00 AM

Work Order ID: 73953

Parent Item: D3529-1

Parent Item Name: Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Page 1

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 06-06-28 JLM

IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| MUHMWB10 | | Purchased | No | | | 100 | sf | 623.6200 | 1.265 | 5.326316 | | | - |
| LUMW 1" Disab | | | | | | | | | | R | 11- 92 | ۵, | |

UHMW 1" Black

| Location | Loc Qty | Loc Code | |
|----------|---------|----------|--------|
| MAT018 | 383.62 | | |
| 117321 | 76.6 | | |
| 117738 | 124.3 | | |
| 117819 | 99.3 | | |
| 118257 | 83.42 | | |
| ST | 240 | | |
| 118814 | 240 | | 118814 |

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|------------|------|---------------------------------------|------------|---------------------------|-----------|----------|-----------|------|-------------------------------|--------------------------|
| W/O: | | | V | ORK ORDER CHA | NGES | | | | | |
| DATE | STEP | PRO | OCEDURE CH | IANGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No | | PAR #: | | | | | | | | |
| | R | esolution: | Disposit | ion: | QA | : N/C CI | osed: | | Date: _ | |
| NCR: | | | WORK OR | DER NON-CONFO | RMANCE | (NCF | ?) | | | • |
| DATE | STEP | Description of NC | Initial | | Section B | Sign 8 | Verific | | Approval | Approval |
| | | Section A | Chief Eng | Action Descript Chief Eng | .ion | Date | Section | on C | Chief Eng | QC Inspector |
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| DART AEROSPACE LTD | Work Order: | 73953 |
|------------------------------|--------------|-------------|
| Description: Bearpaw | Part Number: | D3529-1 |
| Inspection Dwg: D3529 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| X | First Article | Prototype |
|---|---------------|-----------|
|---|---------------|-----------|

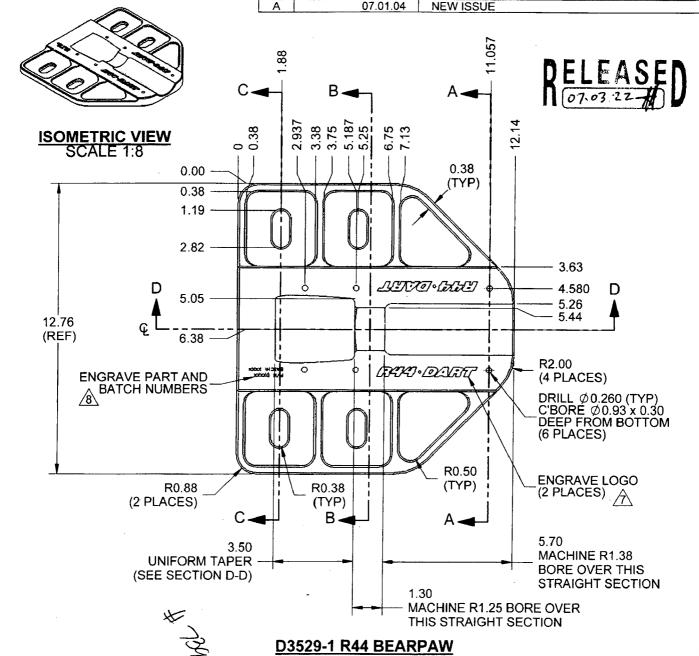
| in Dra | spection Sheet wing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-----------|----------------------------------|-----------------|---------------------|--------|--------|-------------------------|---|
| Α | 5.50 | +/-0.030 | 5.495 | 1 | | Vern FKO4 | |
| В | 0.07 x 45° | +/-0.030 x 0.5° | .07 x 45° | V | | <i>(</i>) . | |
| С | R0.25 | +/-0.030 | . 25 | 7 | | rad gama | · |
| D | 0.250 | +/-0.010 | .253 | V | | Vern Fkou | |
| Е | 0.625 | +/-0.010 | .620 | 7 | | 1/1 | |
| F | 0.950 | +/-0.010 | .944 | 1 | | 1 | |
| G | 1.63 | +/-0.030 | 1.62 | 7 | | p | |
| Н | 12.14 | +/-0.030 | 12.15 | V | | Tape FKOS | |
| | | | | 3 | | | |
| J | 5.70 | +/-0.030 | 5.70 | 7 | | Venn FK04 | |
| K | 0.375 | +/-0.010 | .37.7 | 7 | | 1, | |
| L | 0.525 | +/-0.010 | .530 | 7 | | 1/ | |
| М | 0.13 x 45° | +/-0.030 x 0.5° | -160×45° | 7 | | 10 | |
| N | R0.50 | +/-0.030 | .50 | 7 | | rad gamo | |
| 0 | 12.76 | +/-0.030 | 12,775 | 7 | | Tour FKOS | |
| Р | 3.38 | +/-0.030 | 3.38 | 7 | | Vern Fko4 | |
| Q | 3.75 | +/-0.030 | 3.75 | 7 | | 11 | |
| R | 5.187 | +/-0.010 | 5,189 | 1 | | /1 | |
| S | 5.25 | +/-0.030 | 5,25 | 7 | | / | |
| Т | 7.13 | +/-0.030 | 7,13 | 7 | | Tape FKOS | |
| U | Ø0.260 | +0.006/-0.001 | . 760 | 7 | | Vern Fkou | 7 |
| V | 0.30 | +/-0.030 | -313 | 7 | | 1, | 1 |
| W | 0.93 | +/-0.030 | .93 | 7 | | 17. | |
| Х | 1.30 | +/-0.030 | 1.30 | 1 | | ٠ | *************************************** |

| Meas | ured by: | F.K. /SL | Audited by: | on | Proto | type Approval: | N/A |
|------|----------|------------------|-------------|---------|-------------------|----------------|----------|
| | Date: | 11/10/19. | Date: | 11/1/20 | | Date: | N/A |
| Rev | Date | Change | | € | | Revised by | Approved |
| Α | 07.05.01 | New Issue | | | | KJ/JLM 1,0 | |
| В | 08.05.06 | Dimension I remo | ved 🕜 | | · · · · · · · · · | KJ/DD | 1 |

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| W/O: | | | W | ORK ORDER CHAI | NGES | | | | |
| DATE | STEP | PRO | OCEDURE CH | IANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC inspector |
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| Part No | • | PAR #: | | teanne | NCD: Vo | c No DC | ١٨٠ | Dates | 1 |
| | | esolution: | | | | | | | |
| NCR: | | | | DER NON-CONFOR | | | · . | | |
| DATE | CTED | Description of NC | | | Section B | Verif | ication | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | ۱&∖∣ _{Sec} | tion C | Chief Eng | QC Inspector |
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| DESIGN DRAWN BY CB | | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | | |
|--------------------|------|----------|---|------------------------|--|--|--|
| CHEC | (ED) | APPROVED | DRAWING NO. D3529 | REV. A SHEET 1 OF 2 | | | |
| 07.01.04 | | | R44 BEARPAW | SCALE 1:4 | | | |
| REV | | DATE | DESCRIPTION | | | | |



NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- FINISH: NONE
- PART IS SYMMETRIC ABOUT ©
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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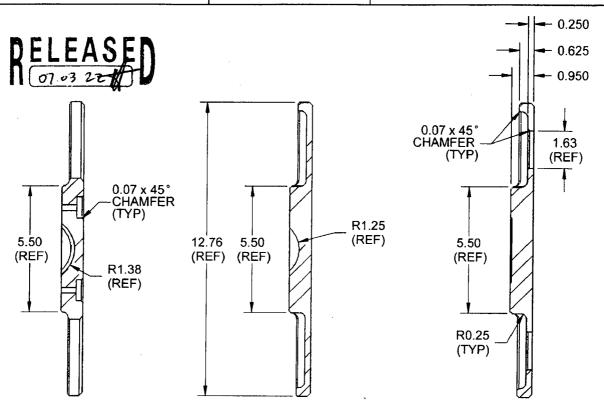
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| W/O: | | | WC | ORK ORDER CHANG | ES | | | | |
| DATE | STEP | PROCEDURE CHANGE | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| Part No: | | PAR #: | Fault Cate | gory: | _ NCR: Yes | No DQ | A: | _ Date: _ | |
| Resolution: | | | Dispositio | QA: N/C Closed: Date: | | | | | |
| NCR: | | , | WORK ORD | ER NON-CONFORMA | ANCE (NCR | 1) | , | | |
| DATE | STEP | Description of NC | Corrective Action Section B | | | Verifi | cation | Approval | Approval |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Sect | ion C | Chief Eng | QC Inspector |
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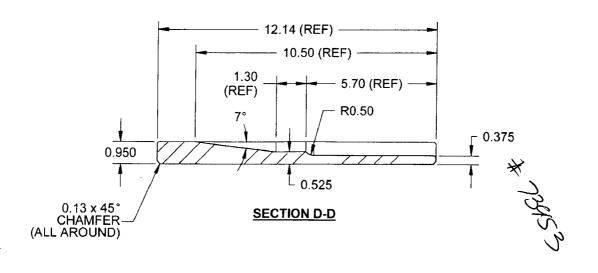
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|-------------------|----------|-------------|--|--|--|--|--|
| CHECKED 2 | APPROVED | DRAWING NO. | REV. A | | | | |
| _ - 19 | | D3529 | SHEET 2 OF 2 | | | | |
| DATE | 24.24 | TITLE | SCALE | | | | |
| 07 | .01.04 | R44 BEARPAW | 1:4 | | | | |



SECTION A-A

SECTION B-B

SECTION C-C



| W/O: | | WORK ORDER CHANGES | | | | | | | | | |
|-----------------|------|--------------------------------|--|------------------|--------|-------------|----------------|---------------|-------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| Part No: PAR #: | | PAR #: | Fault Ca | legory: | _ NCR: | Yes N | io DQ A | \: | Date: _ | | |
| | | Disposition: 0 | | | WC Clo | sed: | Date: | | | | |
| NCR: | | V | VORK OR | DER NON-CONFORMA | NCE | (NCR) | | | | | |
| DATE STEP | | Description of NC Section A | Initial Action Description Chief Eng Chief Eng | | | Sign & Date | | ation on C | Approval Chief Eng | Approval QC Inspector | |
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